Date: Tuesday, 8/28/2007 3:22:45 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR SLUG
Job Number	: 34307		
Estimate Number	: 10162		
P.O. Number	: N/A	Part Number	: D2587
This Issue	: 8/28/2007 S.O. No. : N/A	Drawing Number	: D2587 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 29067	Material	: N/A
Written By	:	Due Date	: 9/14/2007 Qty: 20 Um: Each
Checked & Approved By	: 07.08.28		
Comment	: Est D 04.05.31 Step 2 changed KJ/JLM Est E 06.07.31 Waterjet EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S040	6061-T6 .040 Sheet

Comment: Qty.: 0.0168 sf(s)/Unit Total : 0.3360 sf(s)
6061T6 alum. sheet 0.040" thick
Batch: M102723 (19) M100742 (1) SAD 07/08/31

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D2587
Dwg Rev: A1
Prog Rev: A1
2-Deburr if necessary
07/09/06 19 SAD 07/08/31 20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/08/31 20

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK 07/09/06 Counts X20

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1 07-09-11 20

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: [illegible] Date: 07/09/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/06	# 22	one parts was lost while deburring. P-C Human error	QSX042	Remind employees to take better care of parts while Deburring Replace B# M100742	Er 07/09/10 SAD 07/09/10	07/09/10	QSX042	Er 07/09/10

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** DOOR SLUG

Job Number: 34307 **Part Number:** D2587

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT ALODINE	07/09/11 (20)
7.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 37	07/09/11 (20)
8.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(20) 07/09/11

Job Completion

07-09-11

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34307
Description: Door Slug	Part Number:	D2587
Inspection Dwg: D2587 **Rev:** A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	+/-0.010	1.495	✓		Vern	
0.040	+/-0.010	0.037	✓		Vern	

Measured by:	SAD	Audited by:	CS	Prototype Approval:	N/A
Date:	07/08/31	Date:	07/08/31	Date:	N/A

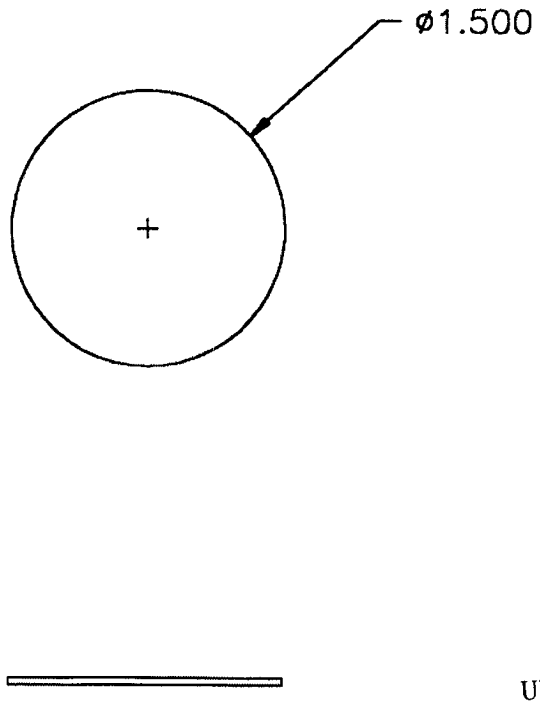
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS		
CHECKED	APPROVED	DRAWING NO.	REV. A
M. M.	M. M.	D2587	SHEET 1 OF 1
DATE		TITLE	SCALE
96:07:11		DOOR SLUG	1:1
A1 KJ	03.09.16	ADD 6061-T6 OPTION	

DART

QA COPY ISSUED

RELEASED
9607/23 BU



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34307

OR 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) A1

MATERIAL: 5052-H32 0.040 THICK
FINISH: ACID ECTCH, ALODINE